

Work Order ID 84054

May-30-12 3:50:51 PM

84054

Page 1

Item ID: D206-667-101TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Turning Detail

Start Date: 02/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/05/13 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D206-667-141

Rev C

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: 4/1DWG REV: 0 C

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

1 ϕ KC 12-11-25

110

QC1- Inspect dimensions to dimension sheet

0.00

110

QC

Memo

0.00

Quality Control

1 ϕ KC 12-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84054

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Page 2

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NS1

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NS2

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Required Date: 16/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

MORI SEIKI CNC LATHE LARGE

0.00

120

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA083

2-Blend transition lines only, **do not sand whole tube**.

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

FOLIO REV:

DWG REV:

3-Remove sand and plugs

1 ϕ KL 12-11-25

130

QC1- Inspect dimensions to dimension sheet

0.00

130

QC

Memo

0.00

Quality Control

1 ϕ KL 12-11-25

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Crosstube Turning Detail

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Cust Item ID:

Required Date: 16/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

JW 12-11-27

145

0.00

145

Crosstubes

Memo

0.00

Crosstubes

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

JW 12-11-27

150

~~Crosstubes Chemical Conversion~~

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

1- Pressure wash x-tube inside & out
2- Acid etch x-tube inside & out
Use red scotch brite.

JW 12-11-27

W/O:		WORK ORDER CHANGES					
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Page 4

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Revision ID:

Item Name: Crosstube Turning Detail

Stop *NS2*

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Required Date: 16/05/2012 Req'd Qty: 1.00 *1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC 5 Inspect Chemical Conversion Coat

0.00

160

QC Memo

0.00

Quality Control

DAS
03
9-89

12-11-28

170 Packaging 0.00

170

Packaging Memo

0.00

Packaging Identify and stock in kanban rack Location: LG

12-11-27

180 QC21- Final Inspection - Work Order Release 0.00

180

QC Memo

0.00

Quality Control

12/11/28

ME
12-11-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-30-12 3:50:55 PM

Page 1

Work Order ID: 84054

84054

Parent Item: D206-667-101TRN

D206-667-101TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 02/05/2012

Required Date: 16/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 remove polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6001-105		Manufactured	No			110	Each	18.0000	1	1			
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D6001-105

Crosstube, Material

Location

Loc Qty

Loc Code

LG

18

29115

18

1

KC 12-11-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>84054</i>
Description: Crosstube Assembly (206B High Fwd)	Part Number:	D206-667-141
Inspection Dwg: D206-667-141 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.243	/		VERN	CNC-08
	2.074	+0.005/-0.000	2.077	/			
	2.074	+0.005/-0.000	2.079	/			
	2.114	+0.005/-0.000	2.118	/			
	2.154	+0.005/-0.000	2.157	/			
	2.194	+0.005/-0.000	2.199	/			
	2.234	+0.005/-0.000	2.239	/			
	0.110	+/-0.010	.120	/			
	0.300 x 30°	+/-0.010	.300	/			
	R0.063	+/-0.010	.063	/		RG	
	R0.500	+/-0.010	.500	/		RG	
	4.438	+/-0.030	4.439	/		VERN	CNC-08
SIDE B	2.240	+0.005/-0.000	2.243	/			
	2.074	+0.005/-0.000	2.077	/			
	2.074	+0.005/-0.000	2.079	/			
	2.114	+0.005/-0.000	2.118	/			
	2.154	+0.005/-0.000	2.157	/			
	2.194	+0.005/-0.000	2.199	/			
	2.234	+0.005/-0.000	2.239	/			
	0.110	+/-0.010	.120	/			
	0.300 x 30°	+/-0.010	.300	/			
	R0.063	+/-0.010	.063	/		RG	
	R0.500	+/-0.010	.500	/		RG	
	4.438	+/-0.030	4.445	/		VERN	CNC-08
	93.18	+/-0.020	93.18	/		TAPE	LG-15

Measured by: <i>KC</i>	Audited by: <i>JW</i>	Prototype Approval:	N/A
Date: <i>12-11-25</i>	Date: <i>12-11-27</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	
B	09.12.14	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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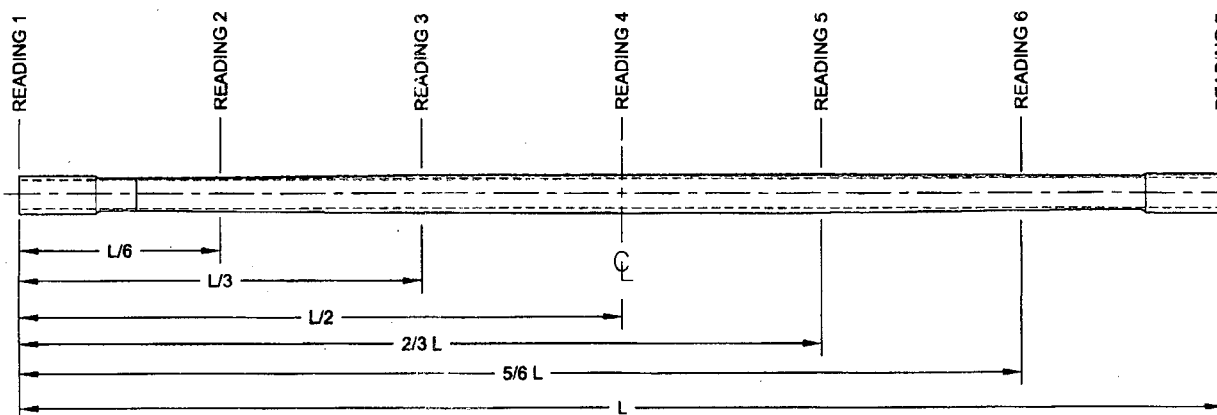
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 84084
Description: Crosstube Assembly (206B High Fwd)	Part Number: D206-667-141
Inspection Dwg: D206-667-141 Rev: C	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.207	.195	.185 .207	.207	.020	0.030"
READING 2 L= 15.53	.146	.130	.124 .141	.141	.022	
READING 3 L= 31.06	.209	.200	.193 .207	.207	.016	
READING 4 L= 46.59	.208	.201	.190 .206	.206	.019	
READING 5 L= 62.12	.208	.202	.194	.204	.014	
READING 6 L= 77.65	.144	.135	.129	.143	.015	
READING 7 L= 93.18	.201	.193	.182	.197	.019	

Calibration Result

Actual Block Thickness: 100-500

Sitescan 250 Measured Thickness: 100-500

Measured by: KC
Date: 12-11-25

Added by: JTW
Date: 12-11-27

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	
B	09.12.14	Dwg Rev updated	KJ	
C	12.06.04	Wall thickness form ended	KJ	

Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 11.3 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 04054 MLO

DEO ATTACHED

12/05/31

OCW #11-615
11.07.26

UNDER REVIEW

04/11/2013

RELEASED
06/11/12/14/15

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D206-667-141 SHEET 1 OF 4 TITLE SCALE CROSSTUBE ASS'Y (206B HIGH FWD) NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	08.11.06		

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8 7 6 5 4 3 2 1

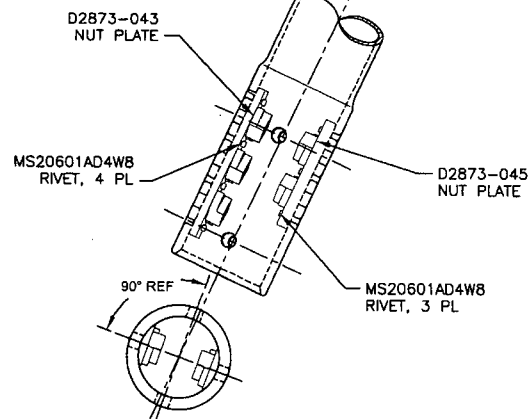
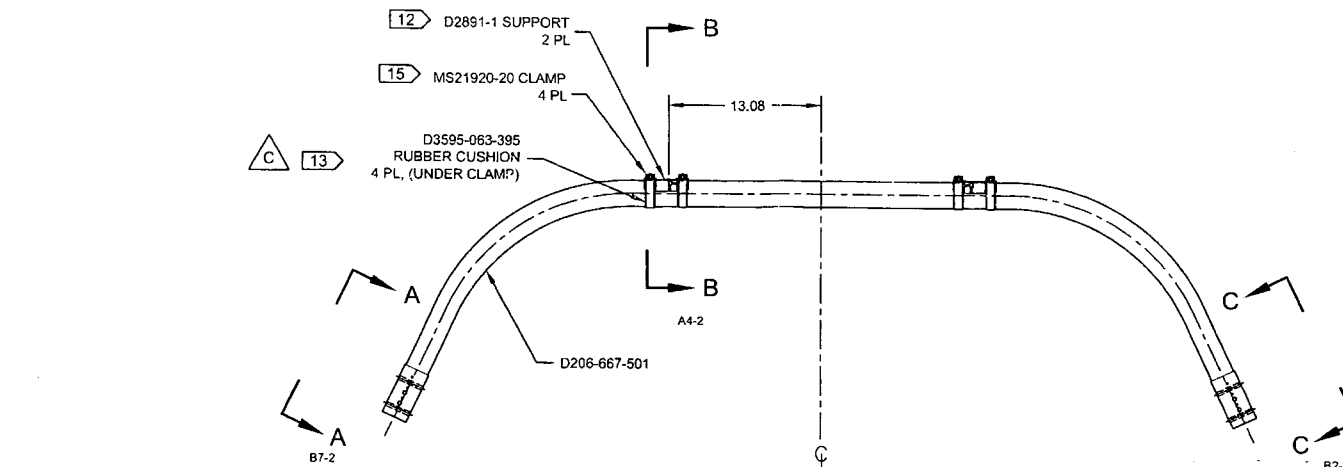
04054

REV 11-615
11.07.28

UNDER REVIEW

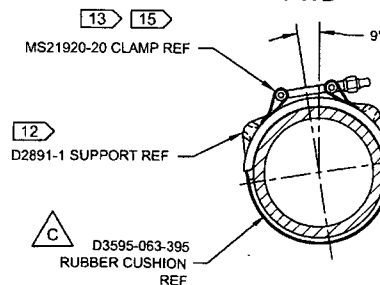
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08/11/2006

DEO ATTACHED

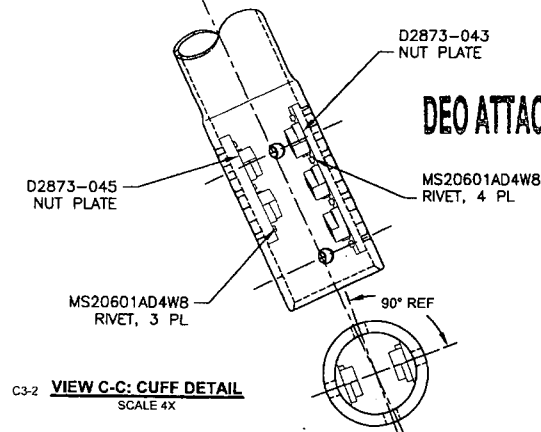


C6-2 **VIEW A-A: CUFF DETAIL**
SCALE 4X

C **D206-667-141**
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



D5-2 **SECTION B-B**
SCALE 5X



C3-2 **VIEW C-C: CUFF DETAIL**
SCALE 4X

DESIGN	40	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	40	DRAWING NO.	REV. C
MFG. APPR.	40	D206-667-141	SHEET 2 OF 4
APPROVED	40	TITLE	SCALE
DE APPR.	40	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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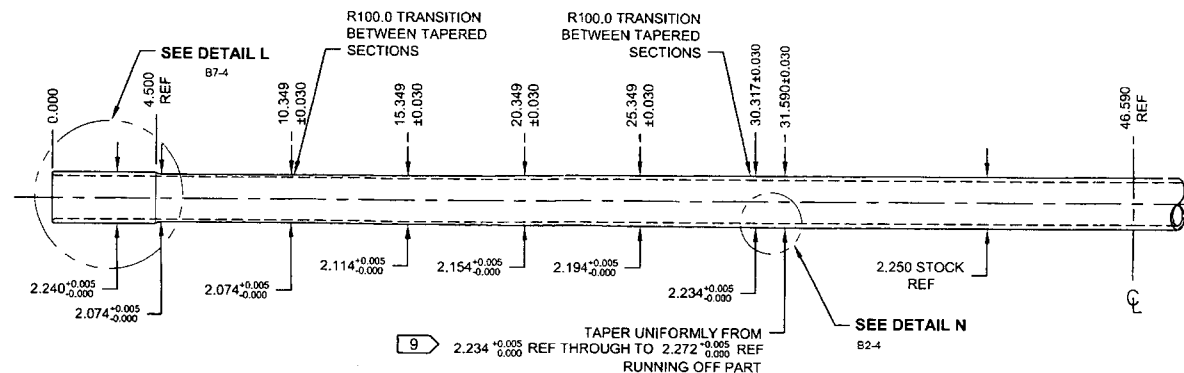
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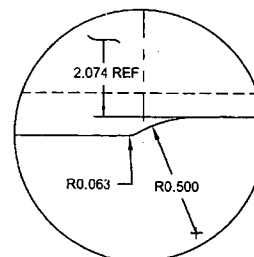
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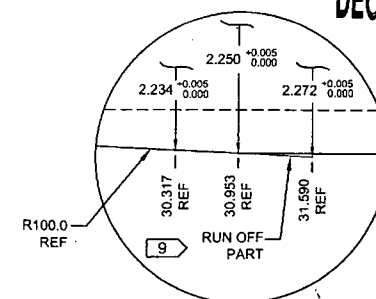
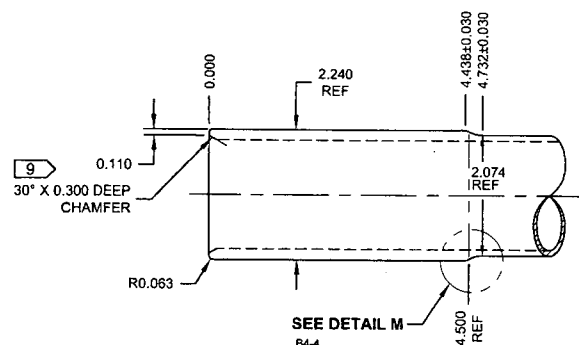
NOTE: Date & initial all entries



TURNING DETAIL



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

RELEASED
08/11/12

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-141	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (206B HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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BCA#11-015
11.07.10
UNDER REVIEW
07/11/08.13

DEO ATTACHED

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NOTE: Date & initial all entries

94054

DRAWING NO. D206-667-141	TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-141-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN P	CHECKED ASS	MFG. APPR. D	APPROVED MD		DE APPR. A		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -141	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries